

42

Date: Tuesday, 10/2/2007 10:39:43 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD MOUNTING LUG
Job Number	: 34934		
Estimate Number	: 10453		
P.O. Number	:	Part Number	: D26162
This Issue	: 10/2/2007	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2616 REV D3
First Issue	: 1 /	Project Number	: N/A
Previous Run	: 27886	Drawing Revision	: D3
		Material	:
Written By	:	Due Date	: 10/15/2007
Checked & Approved By	: <u>07.10.02</u>	Qty:	<u>10</u> Um: Each
Comment	: Est Rev: 00.06.22 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
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Comment: Qty.: 0.1749 f(s)/Unit Total: 3.4986 f(s)
Material: 6061-T6 QQ-A-200/8 2" X 1" Bar
Batch M106563

ml 08/02/0210

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks: 2.000" long +0.030" -0.000"

ml 08/02/0210

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2616-2 & DWG D2616

2-Tumble & Deburr

J.L 08/02/11PTO ->

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/02/11

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 08.02.11(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DZ616-2 PAR #: N/A Fault Category: Prod / Machine NCR: (Yes) No DQA: JD Date: 08/03/06
 QA: N/C Closed: JA Date: 08/03/06

NCR: 34934		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/10	3	- 2 part Ø.8115 -812 are are being opened at .8135 by .811 reamer	<u>JA</u> 08/04/2	- scrap + replace (Qty 82) B# 106563	J.L 08/02/10	<u>JA</u> 08/02/11	<u>JA</u> 08/04/2	<u>JA</u> 08/04/11

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 10:39:43 AM
User: Kim Johnston

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Drawing Name: FWD MOUNTING LUG

Job Number: 34934

Part Number: D26162

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-02-12

(10)

7.0

POWDER COATING

POWDER COATING



M106442



(10X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Mask large hole

m-l 08/02/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-13

(X10)

9.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2611	Bearing	

Batch

536029 (10X)

B 37888 (10X) 50

8/2/14

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Coat bearing in light oil

2-Press Bearing in D2616-2

3-Stack as per Dwg D2616 using DT8019

4- Touch up paint if required

X10

m-l 09/03/03

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/03/03 (X10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 468

5/3/13 36

(10X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 10:39:44 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD MOUNTING LUG

Job Number: 34934

Part Number: D26162

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008/3/04

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 34934
Description: Mounting Lug		Part Number: D2616-2
Inspection Dwg: D2616 Rev: D3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.250	✓			
1.250	+/-0.010	1.249	✓			
0.375	+/-0.010	.375	✓			
0.625	+/-0.010	.626	✓			
Ø0.257	+0.006/-0.001	.258	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	1.998	✓			
1.125	+/-0.010	1.126	✓			
0.313	+/-0.010	.314	✓			
17°	+/-0.5°	17°	✓			
1.259	+/-0.010	1.259	✓			
Ø0.625	+0.008/-0.001					N/A 7/11/08 .02.11
R0.250	+/-0.010	.250	✓			
R0.063	+/-0.010	.063	✓			
Ø0.8115- Ø0.8120	N/A	.8115	✓			

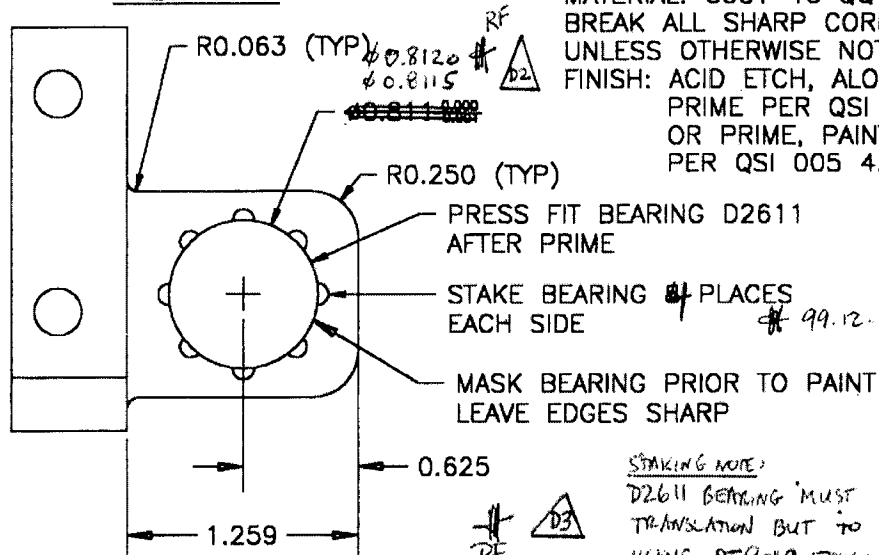
Measured by: J.L	Audited by: J.F	Prototype Approval:	N/A
Date: 08/02/10	Date: 08/02/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	

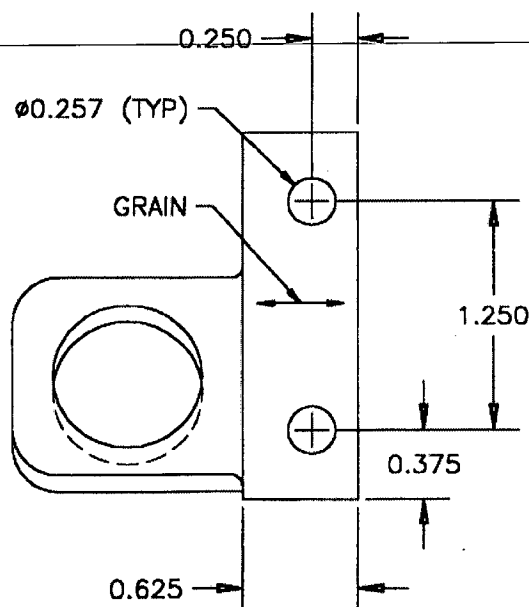
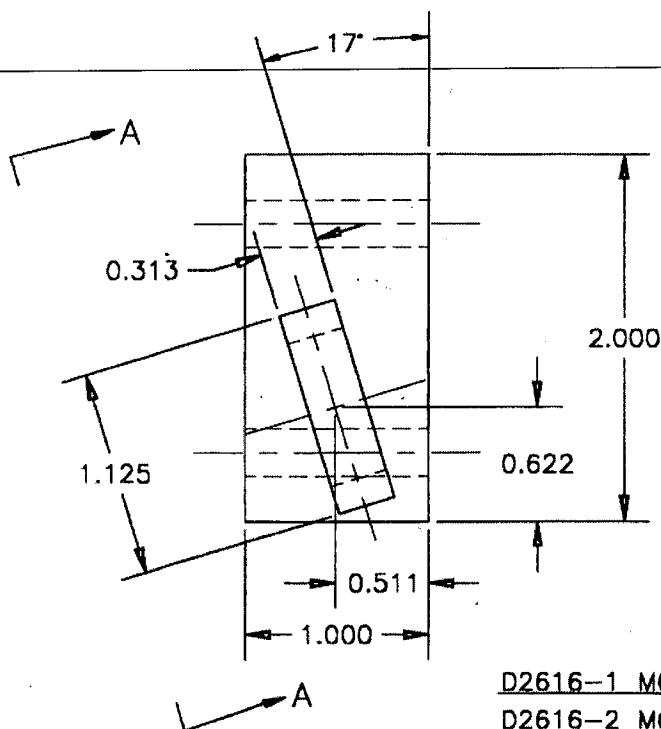


DESIGN <i>BW</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>BW</i>	DRAWING NO. D2616	REV. D SHEET 1 OF 1
DATE 97.07.31		TITLE FWD MOUNT LUG	SCALE 1:1
D1	99.12.16	STAKE 4 PLS INSTEAD OF 8 PLS/SIDE	A
D2	00.11.21	CHG. HOLE TOL. PER NCR 449.	B
D3	02.04.30	ADD STAKING NOTE PER CAR 107	C
D	97.07.31	D2611 WAS CBA-6-B2	

VIEW A-A



RELEASED
(970731) BW



D2616-1 MOUNTING LUG SHOWN
D2616-2 MOUNTING LUG OPPOSITE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34934

